

Derev 55573

Work Order ID 53742

November 16, 2009 11:40:08 AM



Page 1

Item ID: D3504-1

Accept



Setup Start



Revision ID: C

Item Name: Crossbolt Spacer

Stop



Start Date: 11/17/09 Start Qty: 20.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3504

Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

I-TURN AS PER FOLIO FA642 & DWG D3504, 1 FOLIO
REV: *W* DWG REV: *C* 1 2-DEBURR AS REQUIRED

SA 05/12/02

20 *✓*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 05/12/02

20 *✓*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ant 09/12/02

20 *✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53742

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Page 2

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Start Date: 11/17/09 Start Qty: 20.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

LG

0.00



Packaging

Memo

0.00

Packaging

x20

BE 10/01/21

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/22
MF 10-1-21

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 16, 2009 11:40:07 AM

Page 1

Work Order ID: 53742

Parent Item: D3504-1RevC

Parent Item Name: Crossbolt Spacer

Comments:

Start Date: 11/17/09

Required Date: 11/20/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	134.1300	5.9579			



6061-T6 RD Tube .500 x.049W



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

134.13

111028

37.53

111944

96.6

5.99 At RA 05/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53742
Description: Cross Bolt Spacer	Part Number:	D3504-1
Inspection Dwg: D3504 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <i>SD</i>	Audited by: <i>eml</i>	Prototype Approval:	N/A
Date: 08/12/02	Date: 08/12/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.03	New Issue	KJ/JLM	
B	06.12.14	3.480 revised to 3.475	KJ/JLM	
C	08.01.16	Dwg Rev updated	KJ/EC/DD	

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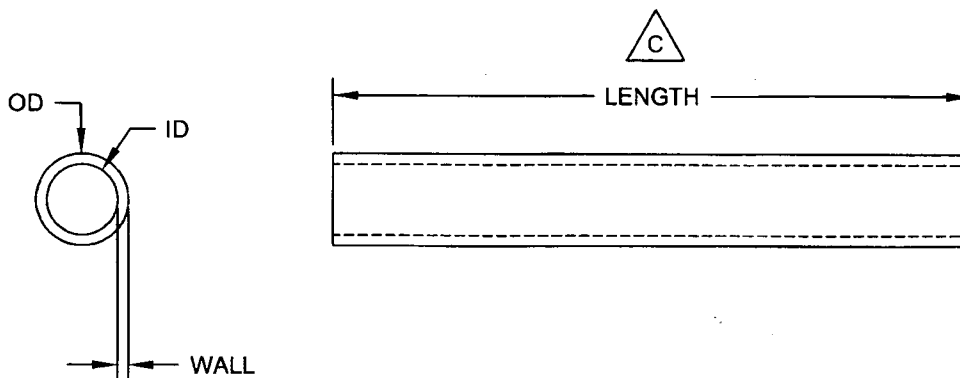
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W053742



D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)

C

D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
07.11.16

C	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3504	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CROSS BOLT SPACER	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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